

Work Order ID: 78606

78606

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January-11-12 2:46:51 PM

Item ID: D3670-4-200

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SPACER

Start Date: 11/01/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3670	Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711 & DWG D3670 FOLIO REV: AA
DWG REV: A
2-DEBURR AS REQUIRED

60 0 2 / 12/01/24

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

60 0 2 / 12/01/24

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

[Signature]

60 0 12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78606***78606***

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January-11-12 2:46:51 PM

Item ID: D3670-4-200 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: SPACER
Start Date: 11/01/2012 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 25/01/2012 Req'd Qty: 60.00 ***60*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 46	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12-2-10 **60**

12/2/13 **46**

12-02-10 **60**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 78606

78606

Parent Item: D3670-4-200

D3670-4-200

Parent Item Name: SPACER

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 60.00

Required Qty: 60.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No				f	201.4560		21.61081			

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

**

22.292'

SL 12/01/24

Location	Loc Qty	Loc Code
MAT013	201.456	
116793	1.667	
116939	19.722	
117400	16.9	
118438	14.584	
119678	148.583	

22.292'

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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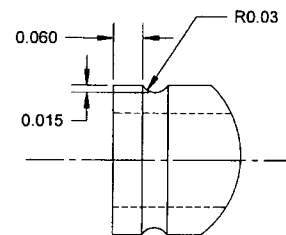
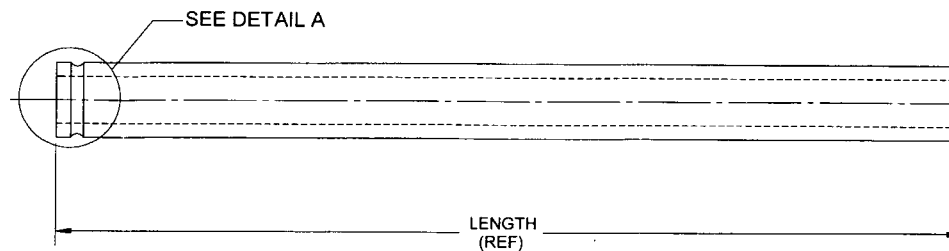
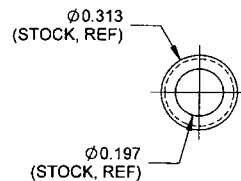
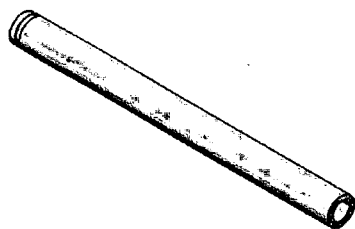
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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANY REVISIONS
WITHOUT NOTICE
WORK ORDER
NO. 38606 M.C.J
12/01/11

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

REV.	NEW ISSUE	DESCRIPTION	DC	07.10.19
DESIGN	DC		BY	DATE
DRAWN	DC			
CHECKED	h			
MFG. APPR.	h			
APPROVED	h			
DE APPR.	h			
DATE	07.10.19			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3670	SHEET 1 OF 1
TITLE SPACER	SCALE 2:1

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W/O:		WORK ORDER CHANGES					
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